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(54) PRODUCTION OF INTERIORLY STERILE CUP, OR BEAKER SHAPED CONTAINER

(57)Abstract:

PURPOSE: To fit sterile means within a time frame of heat molding by eliminating necessity of individual sterile steps to achieve method of producing cup- shaped containers with sterile interior by mixing considerable quantity of an inorganic filler in sheet or web of polymer material and heat-molding.

CONSTITUTION: A starting material is produced by mixing corpuscular inorganic filler with granular or grained polymer material in such a mixing ratio that the quantity of filler is between 40% to 80%, preferably 65%, measured in the total weight of the mixture. These components are extruded at a temperature higher than 190° C equivalent to processing temperature for these polymer material after mixed together in an extruder to form flexible flat sheet or web. Perfectly satisfied sterilization for the web is achieved in such duration as short as 1 to 2 seconds. Heated web at a high temperature is thermoformed in vacuum to form continuous cup or beaker shaped containers. They are fed into sterilized filling chamber after thermoforming as they are and the contents are filled.

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